

Date: Thursday, 2/23/2006 10:24:30 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STA 155 BRACKET

Job Number : 25930

Estimate Number : 11040

P.O. Number : N/A

Part Number : D28042

This Issue : 2/23/2006 S.O. No. : N/A

Drawing Number : D2804 REV B

Prsht Rev. : NC

Project Number : N/A

First Issue : N/A Type : SMALL / MED FAB

Drawing Revision : B

Previous Run : 25714

Material : N/A

Written By : See comment Bkhw

Due Date : 3/22/2006 Qty: 10 Um: Each

Checked & Approved By : 06.02.23

Comment : Est. A00.11.06 New Issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X12000 6061-T6 Bar .50" x 12.0"



Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M100046

J.F. 06/03/12 10

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks per template DT8534

J.F. 06/03/12 10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

J.F. 06/03/12 10

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/03/12 10

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 06.03.12 10

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

J.F. 06/03/12 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:30 AM
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Drawing Name: STA 155 BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BC

0603.12

10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

06.03.14

10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB

06/03/14

10

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP

06/03/15

10

Job Completion



U 0603.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25930
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.127"				
0.125	+/-0.010	0.123"				
R0.125	+/-0.010	R0.125"				
0.250	+/-0.010	.249"				
0.250	+0.000/-0.005	.245"				
0.875	+0.000/-0.001	.874"				
R0.062	+/-0.010	0.062"R				
Ø0.757	+0.005/-0.000	Ø.760"				
R0.625	+/-0.010	R0.625"				
12.304	+/-0.005	12.304"				
Ø0.507	+0.000/-0.001	Ø.506"				
0.437	+0.000/-0.001	.437"				
0.608	+0.000/-0.001	.608"				
Ø0.191	+0.005/-0.000	Ø.192"				
1.420	+0.001/-0.001	1.421"				
0.250 deep	+/-0.010	.244"				
6.933	+/-0.005	6.936"				
7.578	+/-0.005	7.579"				
0.500	+/-0.010	.500"				

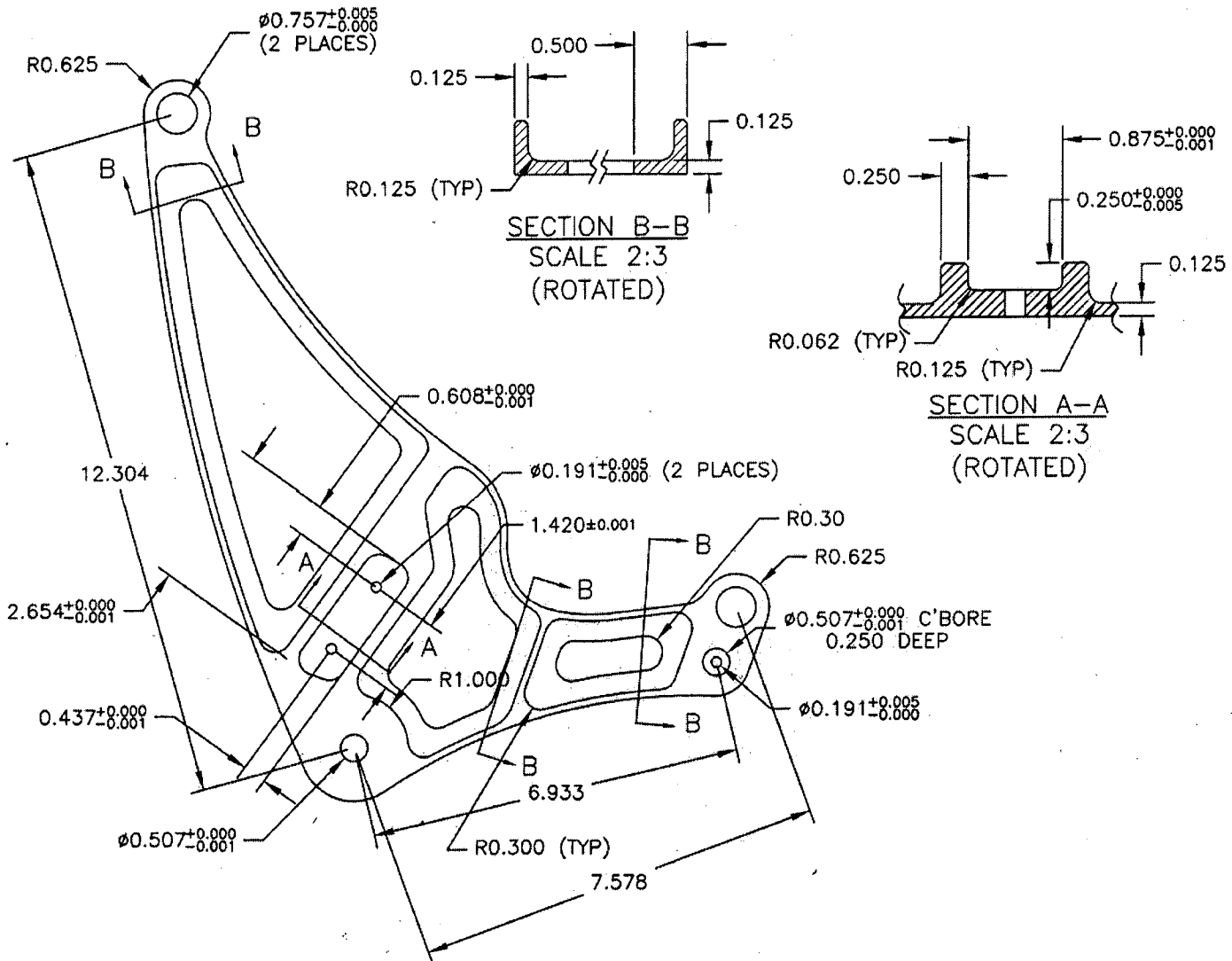
Measured by: J.F.	Audited by: J.G.	Prototype Approval:	N/A
Date: 06/03/11	Date: 06/03/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 2
				D2804	
DATE	04.11.22			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05-03-11 *[Signature]***D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

WORK ORDER

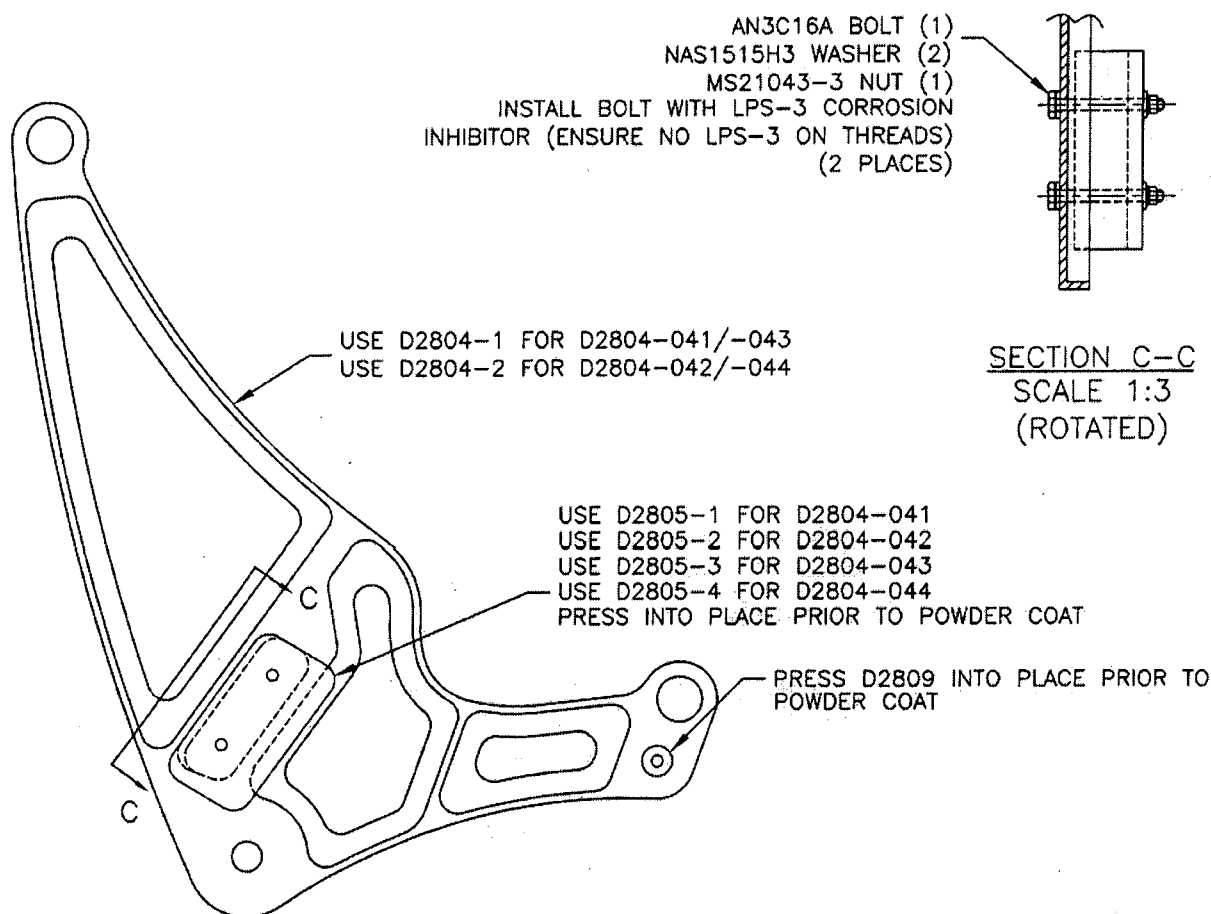
NO. 25930

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
				REV. B SHEET 2 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE 1:3



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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. **25930**

D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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